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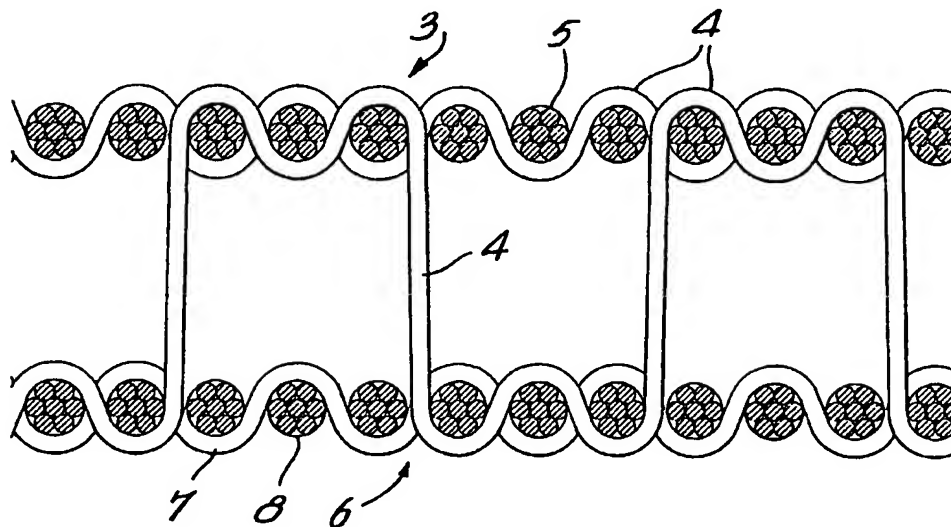
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09/517,323 **2 March 2000 (02.03.2000)** **US**
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- (81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CR, CU, CZ, DE, DK, DM, DZ, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.
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- For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.*

(54) Title: **OUTER SHELL FABRIC FOR FIRE PROTECTIVE GARMENTS FOR FIREFIGHTERS AND FOR WORKERS EXPOSED TO RISK OF FLASH FIRE OR ELECTRIC ARC**



(57) Abstract: The outer shell fabric according to the invention is made of a textile material which is a double-weave woven fabric or a warp-knit knitted fabric constructed in such a manner that preferably a majority of one yarn type is placed on the face of the fabric and the majority of a different yarn type is placed on the back surface. The textile material can be visualized as two separate fabrics being interlaced together by the sharing of yarns between them.



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**Outer Shell Fabric for Fire Protective Garments for Firefighters and
for Workers Exposed to Risk of Flash Fire or Electric Arc.**

TECHNICAL FIELD

This invention relates to textile material for use as the outer shell
5 fabric of a firefighter garment. More particularly, the invention is
concerned with a lightweight outer shell fabric that is constructed of two or
more different yarn types in such a way as to increase resistance to
mechanical and UV degradation while increasing thermal protective
performance. In addition, according to an embodiment of the invention, the
10 textile material can stretch, thereby increasing comfort and mobility.

BACKGROUND ART

All fabrics used in the manufacture of protective clothing for
firefighters must satisfy minimum performance requirements for flame,
heat and tear resistance as prescribed by the National Fire Protection
15 Agency (NFPA).

A firefighter garment is normally made of a composite layer of
materials including an outer shell fabric. All fabrics currently used for the
outer shell fabric of firefighter garments are woven. The warps and wefts
of the outer shell fabric usually comprise spun yarns that are either made up
20 of homogeneous fibers or intimate blends of different fibers. The purpose
of using intimate blends of fibers in yarns is to combine the individual
strengths of each of the constituent fibers. However, since each fiber has
its own weaknesses as well as strengths, the resulting intimate blend yarn
must necessarily have some performance compromises as well.

25 Many of the fibers used in the yarns used in outer shell fabrics of
firefighter garments have drawbacks: difficulty in absorbing dye stuffs,
poor color retention, UV degradation, fibrillation, poor abrasion resistance.

The fabric may be constructed as a plain, ripstop, twill, herringbone or other traditional weave construction; it will however, appear as a continuous single sheet of yarns. And although there may be a face and a back surface to the weave construction, the face and back surfaces will
5 consist of identical yarns.

An alternative to spun yarns is multi-filamentary yarns. The latter have a much higher strength-to-weight and strength-to-denier ratios than the spun yarns of similar fibers. They are also more abrasion resistant and less water absorbing than spun yarns of the same fiber.

10 The principal disadvantages to multi-filamentary yarns are that the resulting fabrics are susceptible to yarn slippage.

The woven fabrics currently used as the outer shell fabric of fire protective garments, whether constituted of spun yarns, multi-filamentary or both, fray and ravel after being torn, cut or punctured. Fraying and
15 raveling not only degrade the appearance of the garment, they make repairs more difficult, and they may increase the risk of injury to the firefighter wearing the garment.

U.S. Pat. No. 5,299,602 discloses an outer shell fabric wherein the textile material comprises warps of alternating multi-filamentary aramid
20 yarns and wefts of alternating spun aramid and multi-filamentary aramid yarns in a twill weave. The object of the invention disclosed in that Patent was to increase firefighter comfort and mobility without reducing mechanical resistance. However, this fabric is still more vulnerable to yarn and seam slippage than fabrics made with 100% spun yarns. Also as a
25 consequence of the high percentage of multi-filamentary yarns, the fabric ravels and frays when cut or torn. Furthermore, the fabric has a preponderance of Kevlar® yarns on the face surface of the fabric and

Kevlar® is more subject to mechanical and ultraviolet (UV) degradation than either spun or multi-filamentary Nomex®.

U.S. Pat. No. 5,527,597 discloses a woven firefighter fabric that incorporates a core-spun yarn (a Lycra® core protected by a polybenzimidazole/aramid wrap) to impart a degree of elasticity to the fabric. Although the Patent claims that the fabric maintains its elasticity after five minutes at 500° F, the literature reveals that Lycra® is not thermally stable in firefighting environments: if stretched at temperatures above 370-390° F., Lycra® will lose its elasticity; above 415° F., Lycra® begins to char and lose its properties. Therefore, this stretchable fabric would suffer irreversible degradation in a firefighting environment.

It is therefore an object of one embodiment of the present invention to provide a stretchable fabric wherein the yarns such as aramid yarns would maintain their integrity at temperatures in excess of 600° F.

It is another object of the present invention to provide a textile material for the outer shell fabric of a firefighter garment that is lightweight yet has increased abrasion, tear, and UV resistance.

It is another object of the present invention to provide a textile material for the outer shell fabric of a firefighter garment that has a higher thermal protective performance rating than conventional fabrics of the same weight and fiber type.

It is another object of one embodiment the present invention to achieve elasticity through the inherent stretchiness of a warp knit construction and not through the introduction of thermally unstable elastomers.

It is a further object of the present invention to provide a textile material that can be used to produce a firefighter outer shell fabric that is

more resistant to fraying and raveling than the currently used woven fabrics.

DISCLOSURE OF INVENTION

In accordance with the present invention, there is provided a textile material to constitute an outer shell fabric for fire-resistive garments, the textile material being a textile arrangement of at least first and second inherently fire-resistant yarns, the first and second yarns being different from one another, the textile arrangement including interlacing means joining the first and second yarns.

10 Preferably, the textile arrangement is a warp knit or a double weave.

In accordance with a preferred embodiment, the first yarns are of first fiber type, and the second yarns are of a second fiber type or blend of fibers which is different from the first fiber type.

The first yarns may be multi-filamentary yarns of the first fiber type and the second yarns may be spun yarns or multi-filamentary yarns of the second fiber type.

In accordance with another embodiment, the first yarns are exposed on a major part of a face of the outer shell fabric, and the second yarns are exposed on a major part of a back surface of the outer shell fabric. For example, the second yarns are exposed on less than about 15% of the face of the outer shell fabric, the first yarns are exposed on more than about 85% of the face of the outer shell fabric, and the second yarns are exposed on more than about 75% of the back surface of the outer shell fabric.

In accordance with yet another embodiment, the multi-filamentary yarns of the one fiber type are made up of one or more fibers selected from the group consisting of meta-aramid, para-aramid, polyimide, polybenzimidazole, polynosic rayon, polyimide-amide, polybenzoxazole, methacrylic and melamine fibers.

In accordance with another embodiment, the second yarns are spun yarns which are different from the first yarns and are made up of a fiber or a blend of fibers different from the multi-filamentary yarns, and selected from the group consisting of meta-aramid, para-aramid, polyimide, polybenzimidazole, polynosic rayon, polyimide-amide, polybenzoxazole, methacrylic and melamine fibers.

In accordance with yet another embodiment, the second yarns are multi-filamentary yarns which are different from the first yarns and are made up of a fiber or a blend of fibers selected from the group consisting of meta-aramid, para-aramid, polyimide, polybenzimidazole, polynosic rayon, polyimide-amide, polybenzoxazole, methacrylic and melamine fibers. Preferably, the first yarn type consists of meta-aramid fibers and the second yarn type consists of para-aramid fibers. More preferably, the first yarn type consists of Nomex® and the second yarn type consists of Kevlar®.

The textile material according to the invention may comprise at least one additional and different yarn.

When the textile material according to the invention is a warp knit it may be produced by using two bars of different warp yarns on a Raschel machine.

The interlacing means may comprise warp yarns of the first type shared by both upper and bottom surfaces, or may comprise weft yarns of the first fiber type and shared by both upper and bottom surfaces, or may comprise warp and weft yarns of the first fiber type and shared by both upper and bottom surfaces. The interlacing means may comprise knitted loops of yarns, or may comprise an interlacing yarn, which is common to both the face and the base surface.

When the textile arrangement is a double weave, the interlacing means may comprise an interlacing yarn, which is common to both the upper, and the bottom surfaces.

In accordance with another embodiment, the first yarns are of one
5 fiber type, and the second yarns are of a second fiber type, which is different from the one fiber type. The first yarn may be a multifilamentary yarn of the one fiber type and the second yarn may be a spun yarn of the second fiber type or it may be a multifilamentary yarn of the second fiber type.

10 Another possibility is that the first yarn is a spun yarn of one fiber type and the second yarn is a spun yarn of the second fiber type. The spun yarns may be of the same material as the multi-filamentary yarns.

In accordance with another preferred embodiment, the first yarns are more dyeable, more resistant to UV degradation, and more resistant to
15 fibrillation than the second yarns.

In accordance with a preferred embodiment of the invention, multifilamentary yarns comprising fibers such as meta-aramid constitute greater than 85% of the yarns on the face surface of the textile material. Conversely, either spun or multi-filamentary yarns comprising fibers such
20 as para-aramid form more than 75% of the yarns on the back surface of the textile material.

In one embodiment of the invention, a double-weave woven fabric, warp yarns in the face fabric will periodically drop down to become warp yarns in the back fabric. In this manner, the face and back fabrics are
25 interlaced by having common warp yarns. In another embodiment of a double-weave fabric, the interlacing yarns may be weft (fill yarns). It would also be possible to provide interlacing common yarns in both the warp and the weft directions.

In another embodiment of the present invention, a warp-knit fabric, there are no weft yarns, only warp yarns. The warp yarns form continuously interlacing loops to make a length of fabric. In the warp-knit embodiment of the present invention multi-filamentary meta-aramid yarns are placed on one bar while spun or multi-filamentary para-aramid yarns are placed on a second bar. The loops of yarn from one bar are interlaced with loops of yarn from the other bar in a manner such that there is a preponderance of multi-filamentary meta-aramid yarn loops on the face surface and a preponderance of para-aramid spun or multi-filamentary yarn loops on the back surface.

Preferably, the mass of the textile material according to the invention is between about 150 and 285 g/m².

BRIEF DESCRIPTION OF DRAWINGS

The invention is illustrated, but not restricted, by the annexed drawings of preferred embodiments in which

FIGURE 1 is an illustration in plan view on an enlarged scale of a conventional woven fabric of the prior art;

FIGURE 2 is an illustration in edge view on an enlarged scale of a double-weave fabric according to the invention for the outer shell fabric of a firefighter garment; and

FIGURE 3 is an illustration in plan view on an enlarged scale of the back surface of a warp knit fabric according to the invention.

MODES OF CARRYING OUT THE INVENTION

Referring to FIGURE 1, it will be seen that in a conventional woven fabric 10, the warp yarns 2 and the weft yarns 1 are of the same type of yarns, for example spun yarns and are of the same fiber composition, such as aramid, or an intimate blend of the same fibers.

Turning now to FIGURE 2 which illustrates a double weave, the upper face 3 of the double weave consists of a warp of yarns 4 and a weft of yarns 5, here both Nomex[®], wherein Nomex[®] yarns 4 are predominantly exposed on upper surface 3. Bottom surface 6, on the other hand is a warp and weft weave of yarns 7 and 8, here both Kevlar[®], wherein Kevlar[®] is predominantly exposed on bottom surface 6. The two weaves constituting upper surface 3 and bottom surface 6 are interlaced as shown by means of intermittent warp yarns 4 consisting of Nomex[®].

Referring now to FIGURE 3, the warp knit that is illustrated is a pillar stitch and cord stitch construction as commonly called in warp knit terminology. Warp knit yarns 11 forming the pillar stitch are multi-filamentary Nomex[®] which are exposed on a major part of the face surface 15 of fabric 12, while warp knit yarns 13 are either spun or multi-filamentary Kevlar[®] which are exposed on a major part of the back surface 14 of fabric 12.

It has been found that the textile material according to the invention whether of warp knit or double weave construction has more interstices than current woven outer shell fabrics do. These interstices trap air, which provides additional thermal insulation as measured by the Thermal Protective Performance (TPP) test of NFPA.

Furthermore, because the yarns used on the face (upper) and back (bottom) surfaces of the textile material are of different fiber types, the two surfaces react differently when exposed to heat fluxes in excess of 1.0 cal/cm²/sec. The difference in reactions of the two surfaces causes the fabric to distort itself thereby creating an additional layer of insulating air.

It is understood that modifications are possible within the scope and spirit of the present invention as defined in the appended claims.

CLAIMS

1. A textile material to constitute an outer shell fabric for fire-resistive garments, said textile material being a textile arrangement of at least first and second inherently fire-resistant yarns, said first and second yarns being
5 different from one another, said textile arrangement including interlacing means joining said first and second yarns .
2. Textile material according to claim 1, wherein said textile arrangement is a warp knit.
3. Textile material according to claim 1, wherein said first yarns are of
10 first fiber type, and said second yarns are of a second fiber type or blend of fibers which is different from said first fiber type.
4. Textile material according to claim 3, wherein said first yarns are multi-filamentary yarns of said one fiber type.
5. Textile material according to claim 4, wherein said second yarns are
15 spun yarns.
6. Textile material according to claim 4, wherein said second yarns are multi-filamentary yarns of said second fiber type.
7. Textile material according to claim 1, wherein said first yarns are exposed on a major part of a face of said outer shell fabric.
- 20 8. Textile material according to claim 7, wherein said second yarns are exposed on a major part of a back surface of said outer shell fabric.
9. Textile material according to claim 7, wherein said second yarns are exposed on less than about 15% of said face of said outer shell fabric and said first yarns are exposed on more than about 85% of said face of said
25 outer shell fabric.
10. Textile material according to claim 9, wherein said second yarns are exposed on more than about 75% of the back surface of said outer shell fabric.

11. Textile material according to claim 4, wherein said multi-filamentary yarns of said first fiber type are made up of one or more fibers selected from the group consisting of meta-aramid, para-aramid, polyimide, polybenzimidazole, polynosic rayon, polyimide-amide, polybenzoxazole, methacrylic and melamine fibers.

12. Textile material according to claim 11 wherein said second yarns are spun yarns which are different from said first yarns and are made up of a fiber or blend of fibers selected from the group consisting of meta-aramid, para-aramid, polyimide, polybenzimidazole, polynosic rayon, polyimide-amide, polybenzoxazole, methacrylic and melamine fibers.

13. Textile material according to claim 1, wherein said second yarns are multi-filamentary yarns which are different from said first yarns and are made up of a fiber or blend of fibers selected from the group consisting of meta-aramid, para-aramid, polyimide, polybenzimidazole, polynosic rayon, polyimide-amide, polybenzoxazole, methacrylic and melamine fibers.

14. Textile material according to claim 8, wherein said first yarn type consists of meta-aramid fibers and said second yarn type consists of para-aramid fibers.

15. Textile material according to claim 8, wherein said first yarn type consists of Nomex[®] yarn and said second yarn type consists of Kevlar[®] yarn.

16. Textile material according to claim 1, which comprises at least one additional yarn type.

17. Textile material according to claim 2, wherein said warp knit is produced by using two bars of different warp yarns on a Raschel machine.

18. Textile material according to claim 1, wherein said textile arrangement is a double weave.

19. Textile material according to claim 18, wherein said interlacing means comprise warp yarns of the first fiber type and shared by both upper and bottom surfaces.
20. Textile material according to claim 18, wherein said interlacing
5 means comprise weft yarns of the first fiber type and shared by upper and bottom surfaces.
21. Textile material according to claim 18, wherein said interlacing means comprise warp and weft yarns of the first fiber type and shared by both upper and bottom surfaces.
- 10 22. Textile material according to claim 18, wherein said interlacing means comprise a yarn which is common to both upper and bottom surfaces.
23. Textile material according to claim 18, wherein said first yarns are of one fiber type, and said second yarns are of a second fiber type
15 which is different from said one fiber type.
24. Textile material according to claim 23, wherein said first yarn is a multifilamentary yarn of said one fiber type.
25. Textile material according to claim 23, wherein said second yarn is a spun yarn of said second fiber type.
- 20 26. Textile material according to claim 23, wherein said second yarn is a multi-filamentary yarn of said second fiber type.
27. Textile material according to claim 18, wherein said first yarn is a spun yarn of one fiber type and said second yarn is a spun yarn of said second fiber type.
- 25 28. Textile material according to claim 18, wherein said first yarns are exposed on a major part of a face of said outer shell fabric and said second yarn are exposed on a major part of a back surface of said outer shell fabric.

29. Textile material according to claim 28, wherein said interlacing means comprise an interlacing yarn which is common to both said face and said base surface.

30. Textile material according to claim 1, wherein said first yarns
5 are more dyeable, more resistant to UV degradation, and more resistant to fibrillation than said second yarns.

31. Textile material according to claim 24, wherein said multi-filamentary yarns of said one fiber type is made up of on or more fibers selected from the group consisting of meta-aramid, para-aramid, polyimide,
10 polybenzimidazole, polynosic rayon, polyimide-amide, polybenzoxazole, methacrylic and melamine fibers.

32. Textile material according to claim 25, wherein said spun yarn is made up of a fiber or blend of fibers selected from the group consisting of meta-aramid, para-aramid, polyimide, polybenzimidazole,
15 polynosic rayon, polyimide-amide, polybenzoxazole, methacrylic and melamine fibers.

33. Textile material according to claim 25, wherein said multi-filamentary yarns is different from said first yarn and made up of a fiber or blend of fibers selected from the group consisting of meta-aramid, para-
20 aramid, polyimide, polybenzimidazole, polynosic rayon, polyimide-amide, polybenzoxazole, methacrylic and melamine fibers.

34. Textile material according to claim 27, wherein said spun yarns are made up of fibers selected from the group consisting of meta-aramid, para-aramid, polyimide, polybenzimidazole, polynosic rayon,
25 polyimide-amide, polybenzoxazole, methacrylic and melamine fibers.

35. Textile material according to claim 1, wherein the mass of said textile is between 150 and 285 g/m².

36. Textile material according to claim 1, wherein said interlacing means comprise knitted loops of yarns.

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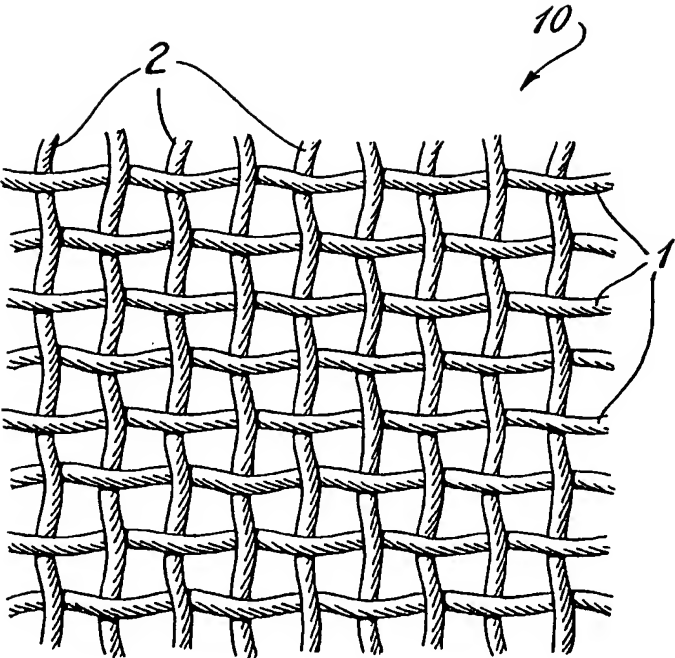


Fig. 1

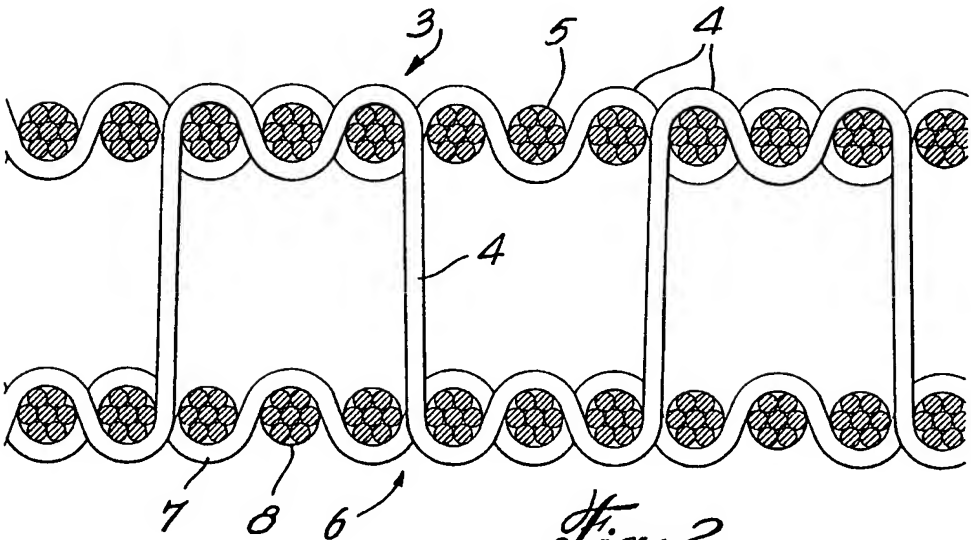
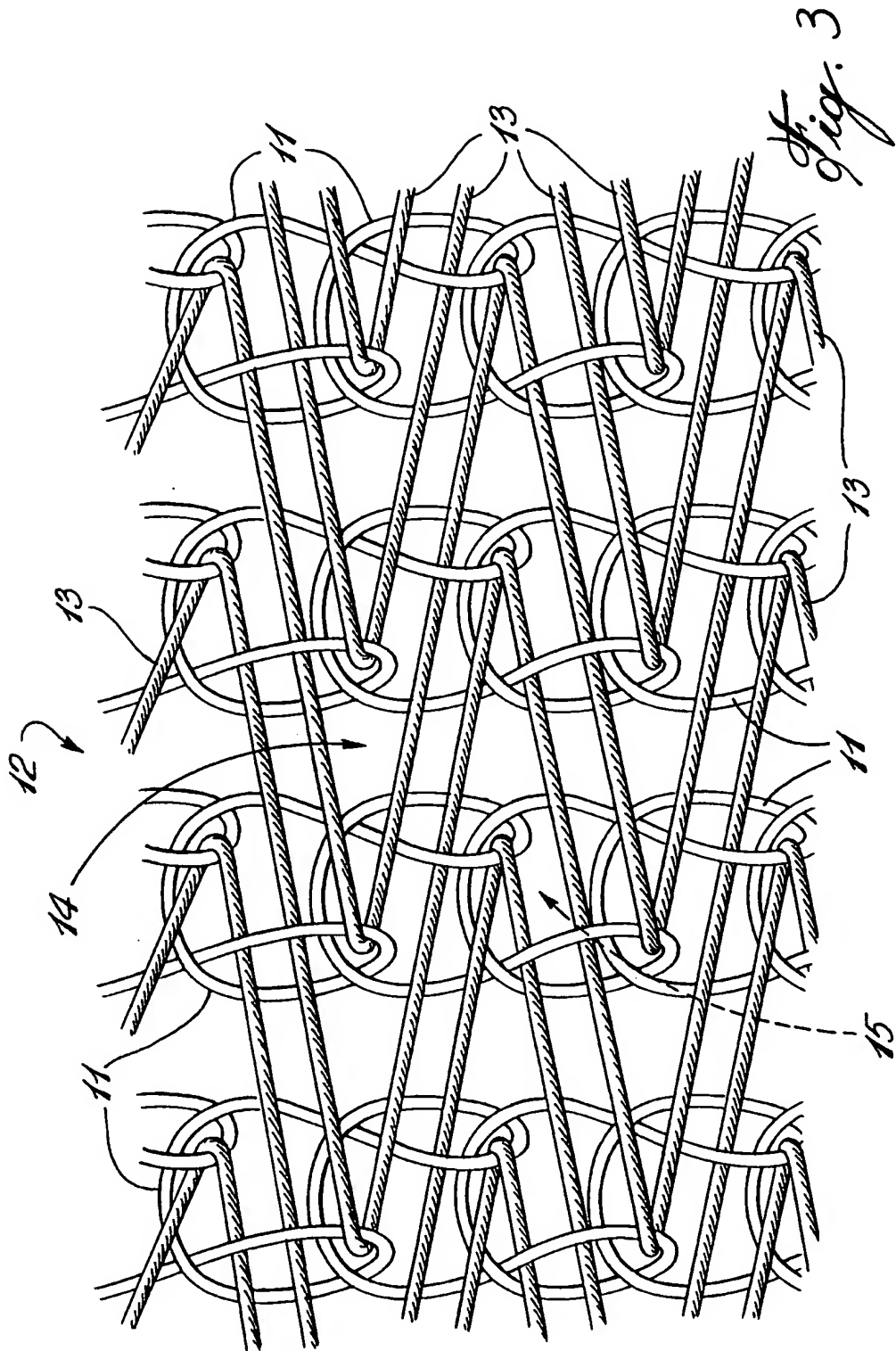


Fig. 2

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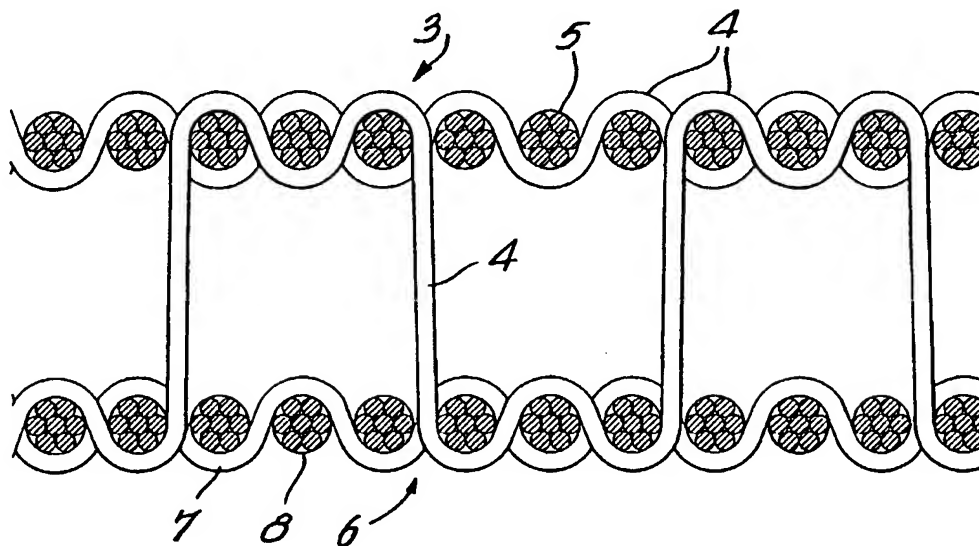
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- (84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).
- (71) Applicant (*for all designated States except US*): MAR-CANADA INC. [CA/CA]; 4200, boulevard St-Laurent, 6e étage, Montréal, Québec H2W 2R2 (CA).
- (72) Inventors; and
- (75) Inventors/Applicants (*for US only*): BARBEAU, Claude [CA/CA]; 1875, rue de la Duchesse, St-Bruno, Québec J3V 3M1 (CA). COCHRAN, Ross [CA/CA]; 553, Grosvenor Avenue, Westmount, Québec H3Y 2S5 (CA).
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(54) Title: OUTER SHELL FABRIC FOR FIRE PROTECTIVE GARMENTS FOR FIREFIGHTERS AND FOR WORKERS EXPOSED TO RISK OF FLASH FIRE OR ELECTRIC ARC



(57) Abstract: The outer shell fabric according to the invention is made of a textile material which is a double-weave woven fabric or a warp-knit knitted fabric constructed in such a manner that preferably a majority of one yarn type is placed on the face of the fabric and the majority of a different yarn type is placed on the back surface. The textile material can be visualized as two separate fabrics being interlaced together by the sharing of yarns between them.



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INTERNATIONAL SEARCH REPORT

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A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 D03D15/12 A41D31/00 D04B21/16

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
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Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EP0-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DE 296 11 356 U (SEIZ) 5 September 1996 (1996-09-05)	1
Y	page 2, line 6 - line 22; claim 1	2-36
A	US 5 299 602 A (BARBEAU) 5 April 1994 (1994-04-05)	1
Y	cited in the application the whole document	2-36
A	GB 2 152 542 A (C.C.DEVELOPMENTS) 7 August 1985 (1985-08-07)	1
Y	the whole document	2-36
A	US 5 691 040 A (BARBEAU) 25 November 1997 (1997-11-25)	

☐ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents :

- *A* document defining the general state of the art which is not considered to be of particular relevance
- *E* earlier document but published on or after the international filing date
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- *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
- *&* document member of the same patent family

Date of the actual completion of the international search

23 August 2001

Date of mailing of the international search report

30/08/2001

Name and mailing address of the ISA

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Boutelegier, C

INTERNATIONAL SEARCH REPORT

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